

Date: Thursday, 9/14/2006 7:30:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 28583	
Estimate Number : 12198	
P.O. Number : N/A	Part Number : D346719
This Issue : 9/14/2006 S.O. No. : N/A	Drawing Number : D3467 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 26979	Material : N/A
Written By : _____	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By : <u>JA 06 09 14</u>	
Comment : est rev. A 06-04-20 new issue EC Est Rev:B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

2.0	M304S26GA	304/316.0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.0776 sf(s)/Unit Total: 0.3104 sf(s)
 304/316 0.018 SHEET batch: 4101000

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 Cut as per Dwg D3467
 Dwg Rev: B
 Prog Rev: B

SAN 08/09/23

④

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 06/09/23

④

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAN 06/09/23

④

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/18/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:30:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28583

Part Number: D346719

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Deburr

2-Form as per dwg D3467 using DT8852

SB 06/00/02 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06-10-02 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 439

GA Took

SB 06/00/02 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/00/02

Job Completion



U 06/00/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

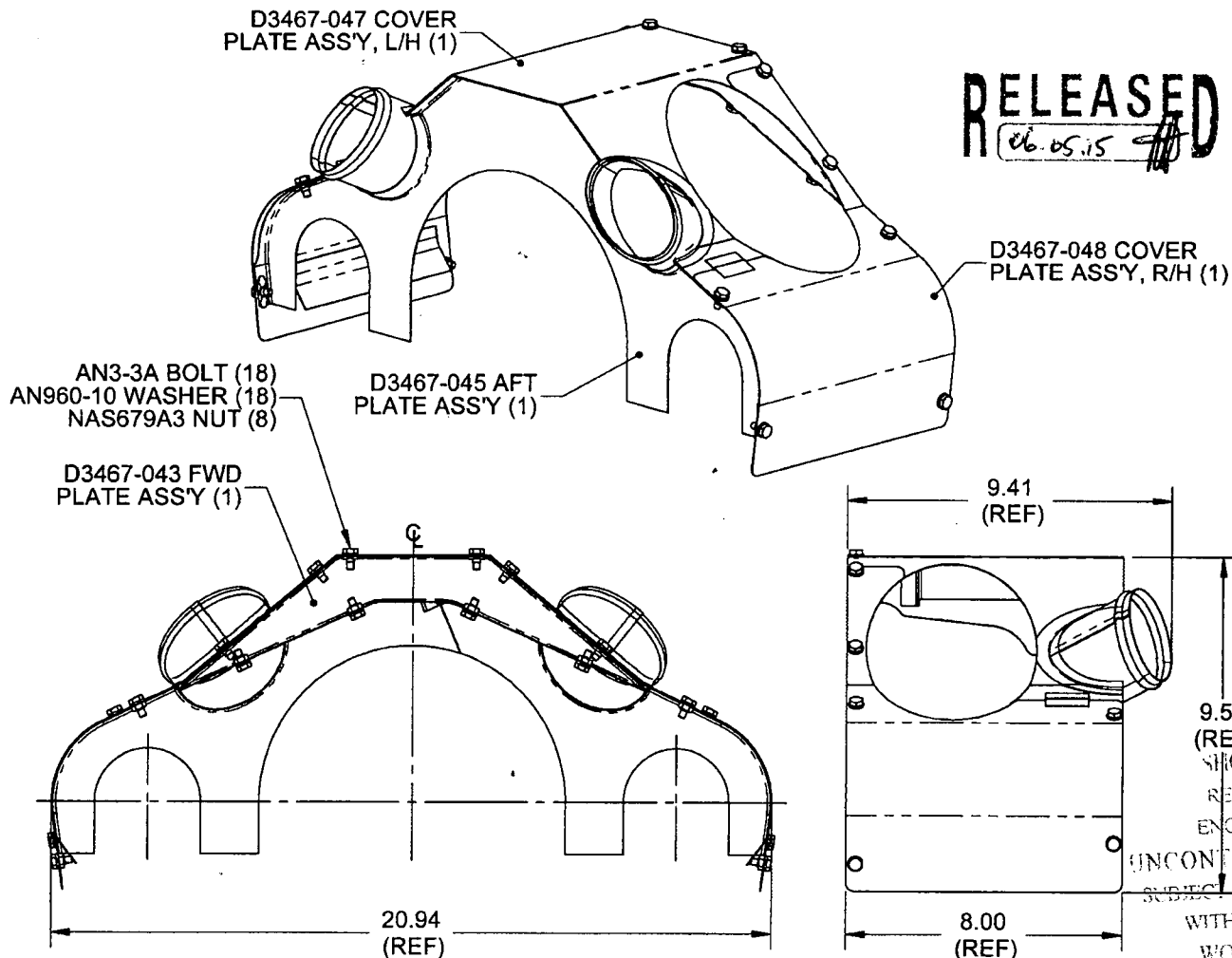
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

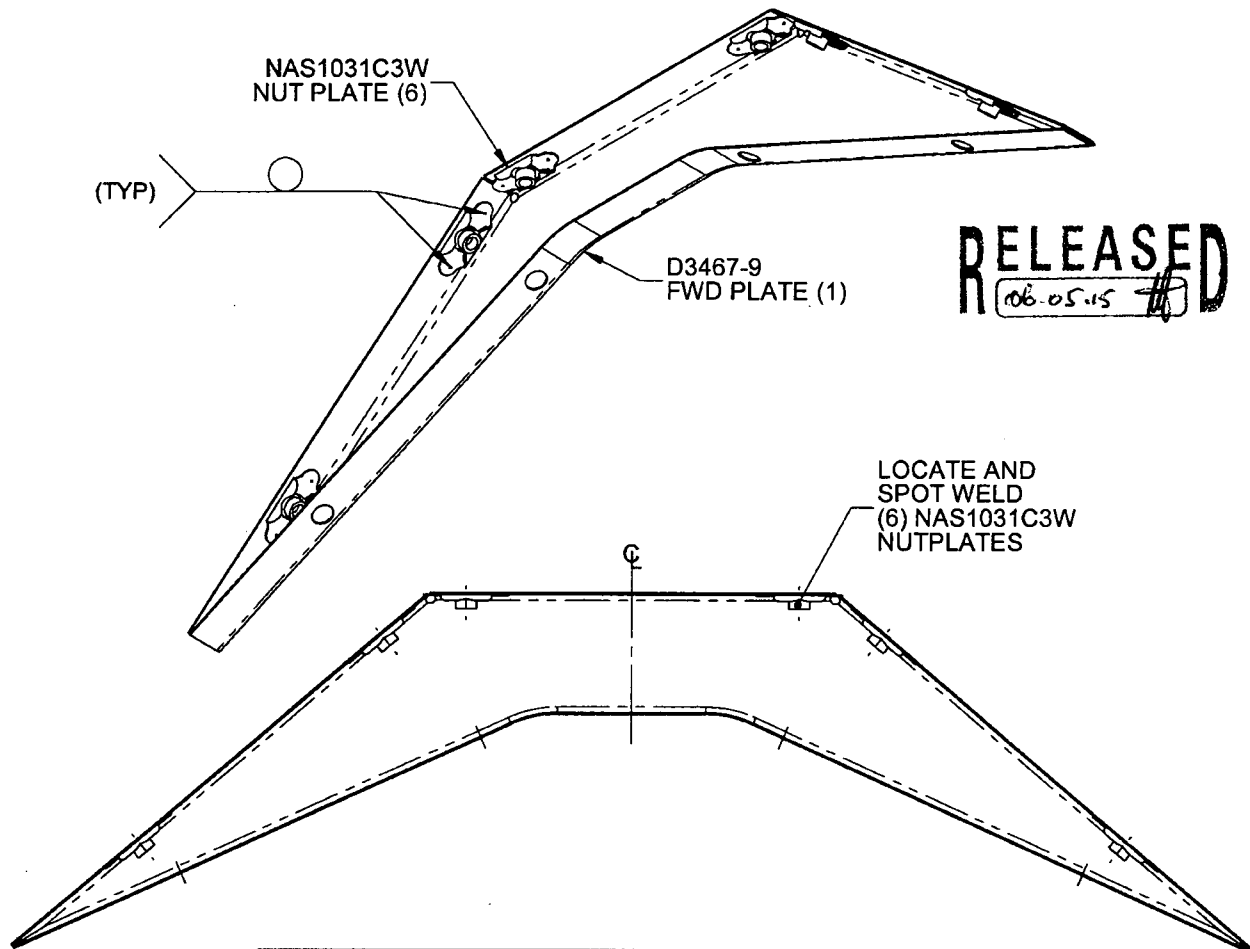
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

D3467-043 FWD PLATE ASSEMBLY**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

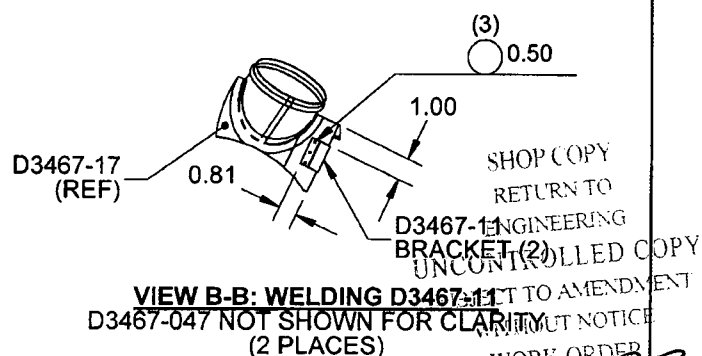
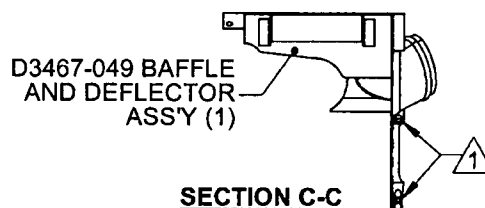
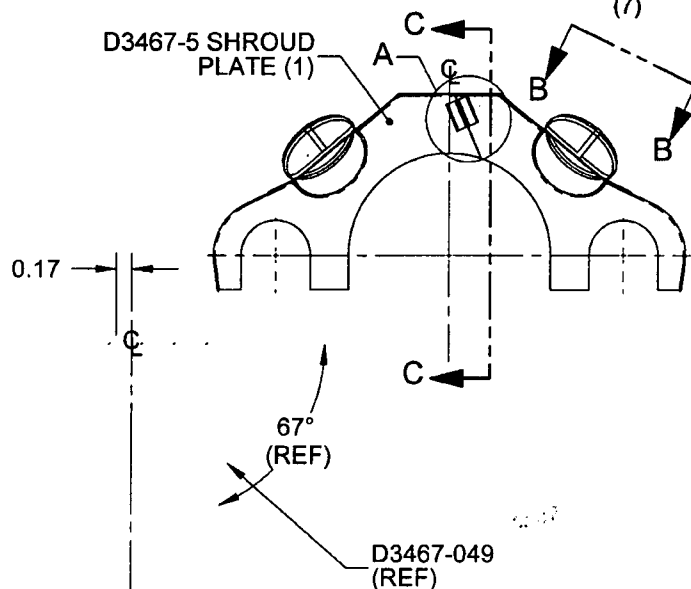
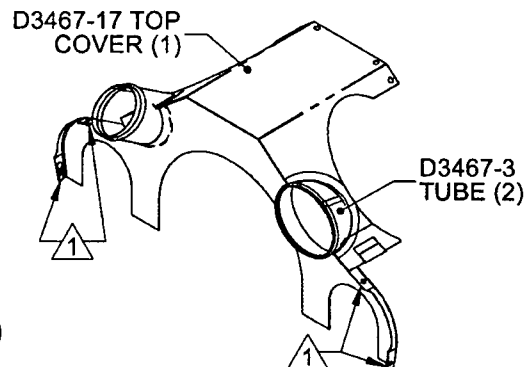
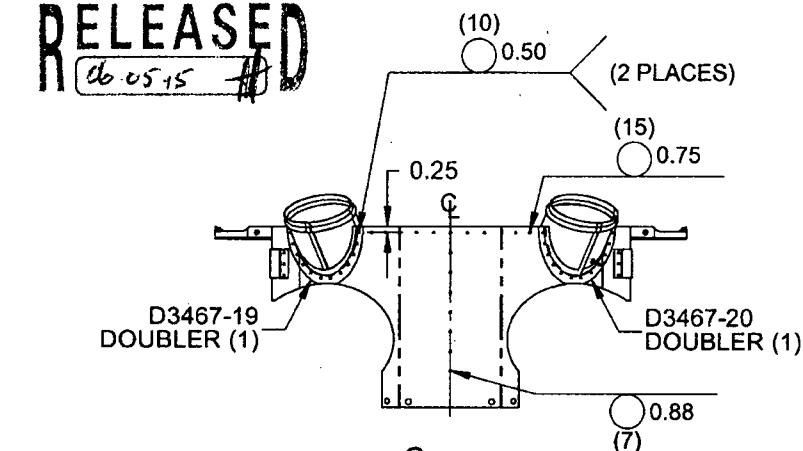
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DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:8

RELEASED
06.05.15**DETAIL A**
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

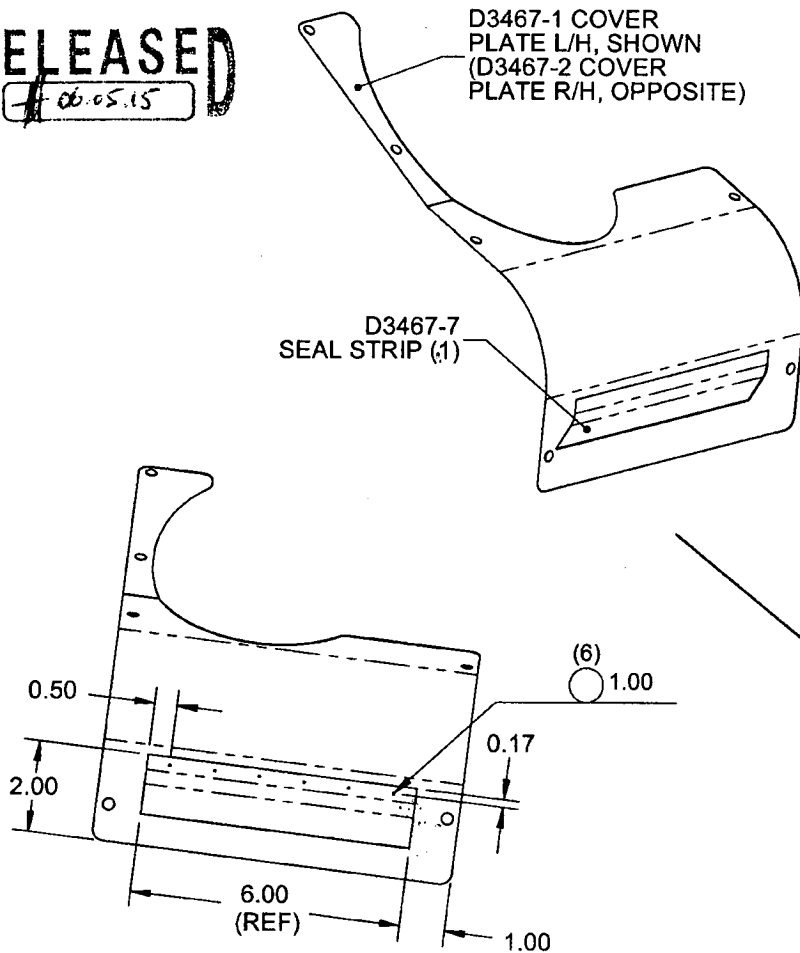
QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
#06.05.15

D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

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NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO
0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

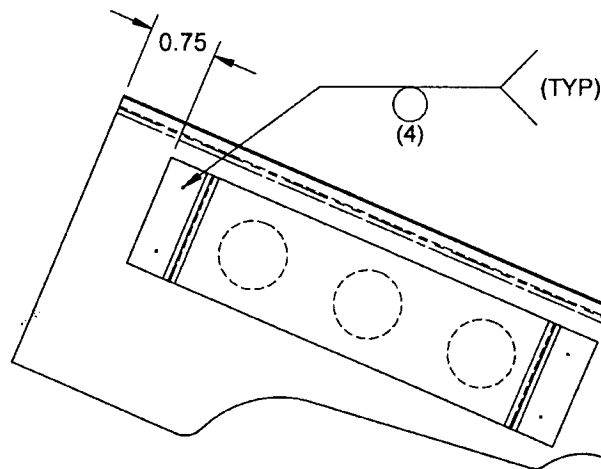
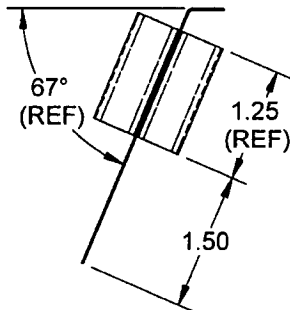
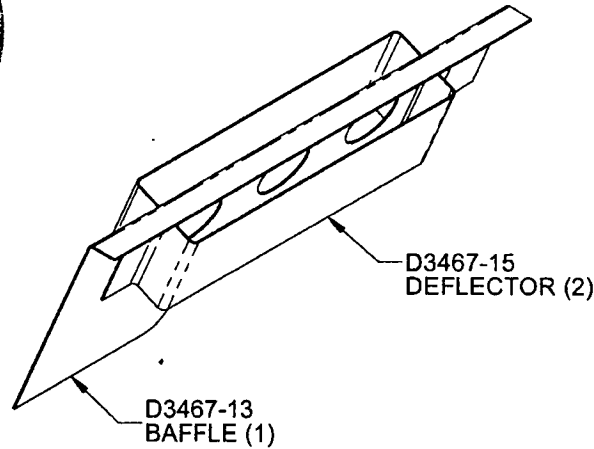
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
06.05.15



D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

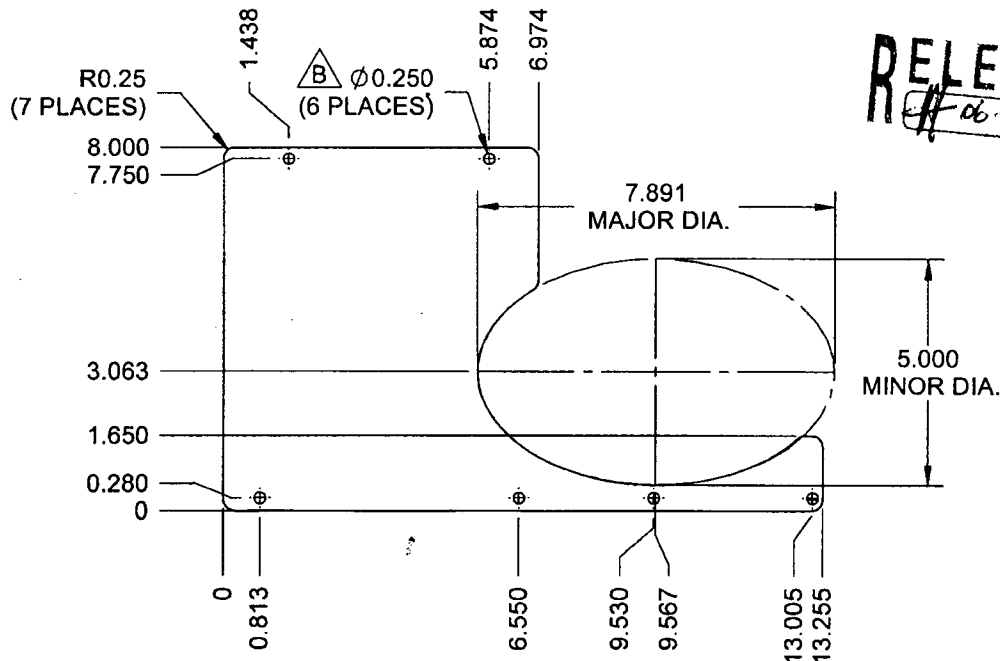
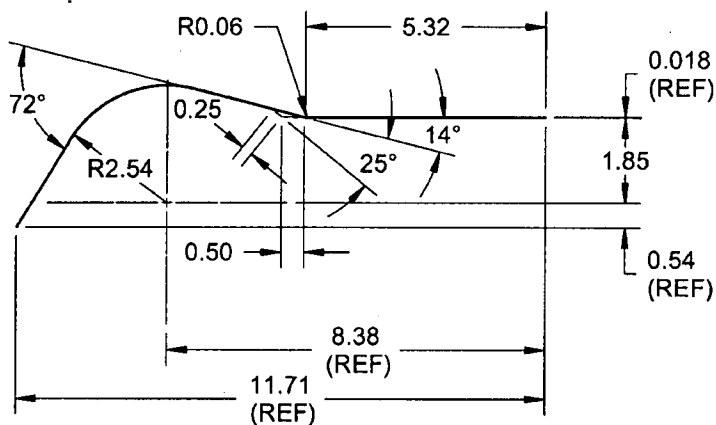
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE
D3467-2 R/H COVER PLATE (OPPOSITE)****D3467-1 L/H COVER PLATE ISOMETRIC VIEW.
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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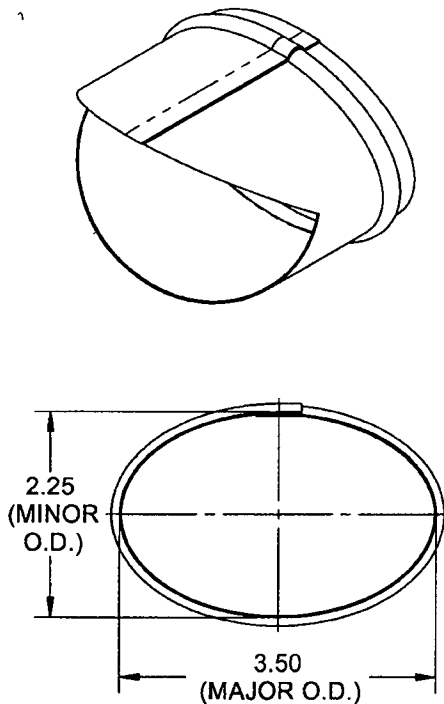
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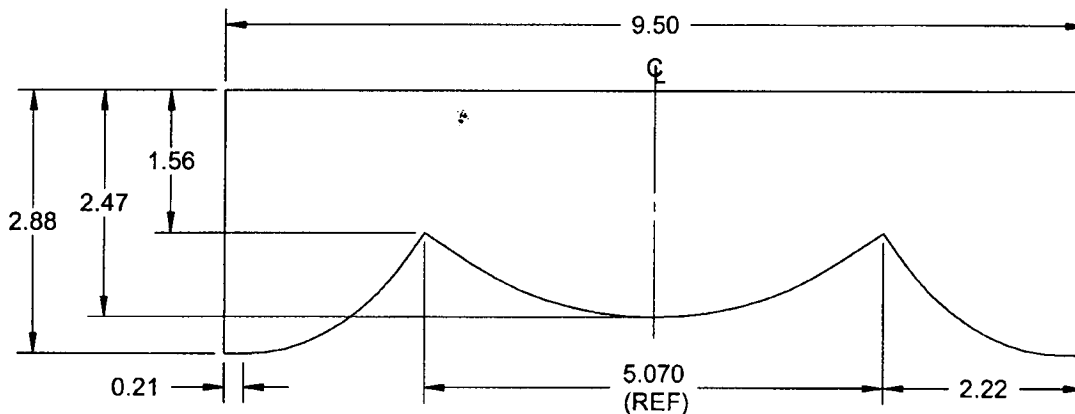
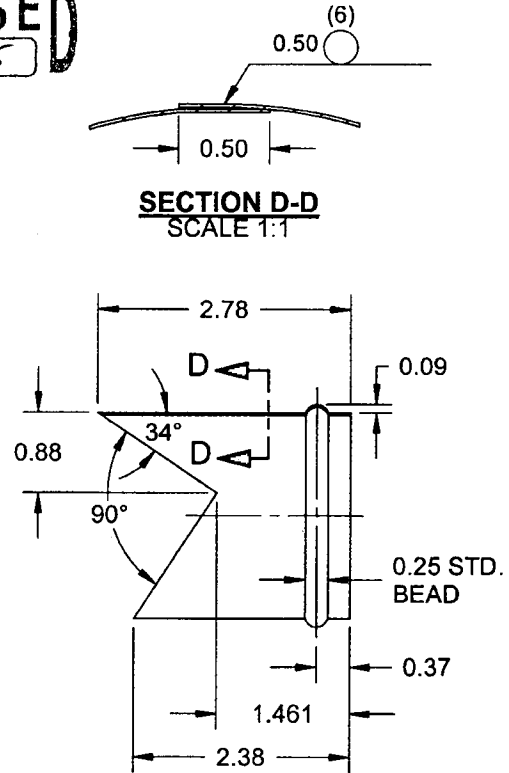


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
06.05.15



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

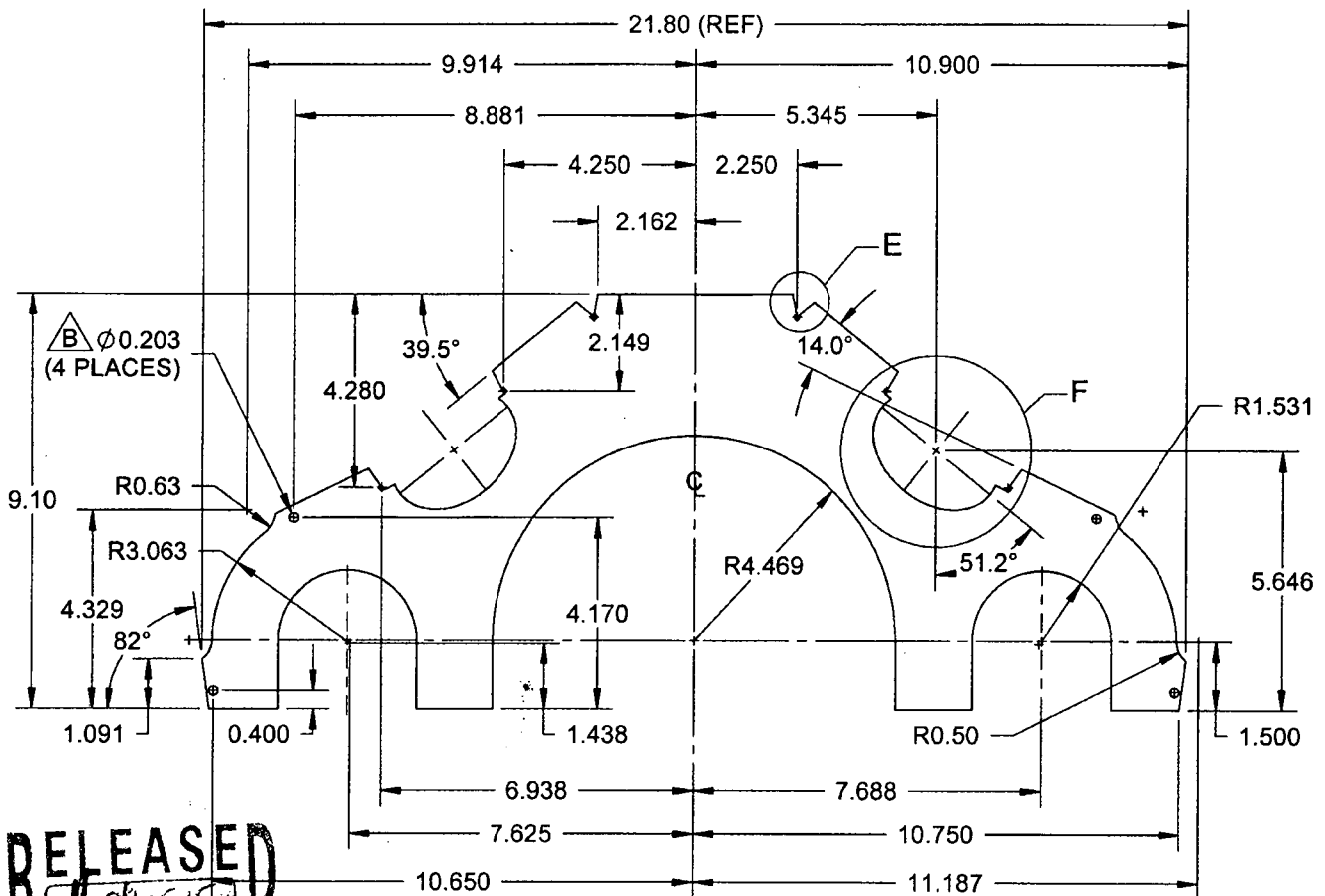
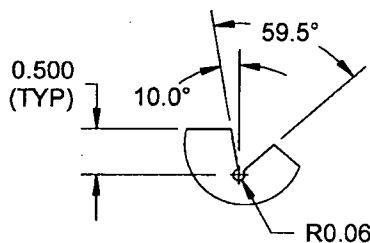
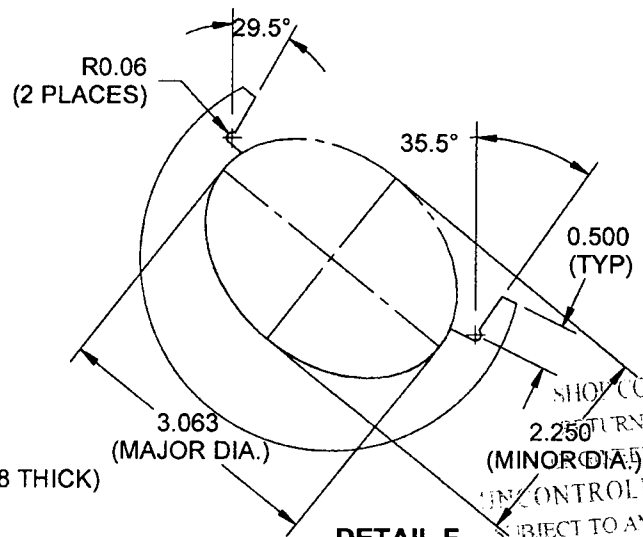
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8

**RELEASED**
06-05-15**DETAIL E**
SCALE 1:2**DETAIL F**
SCALE 1:2**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

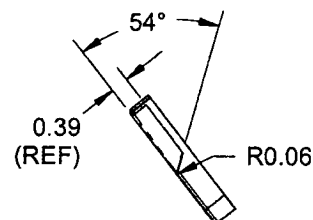
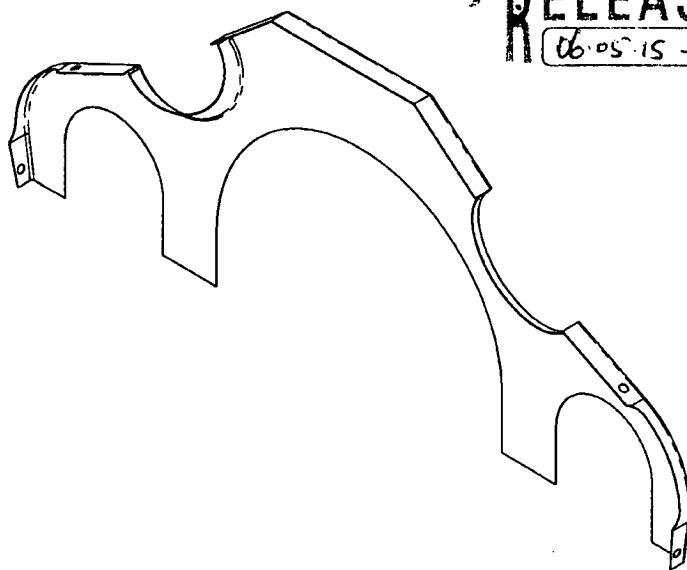
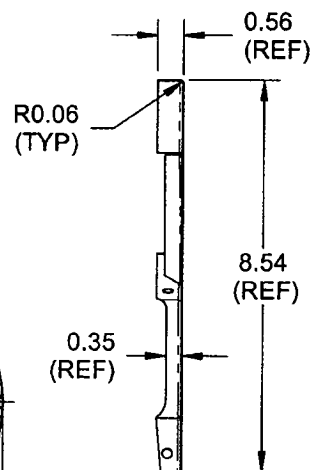
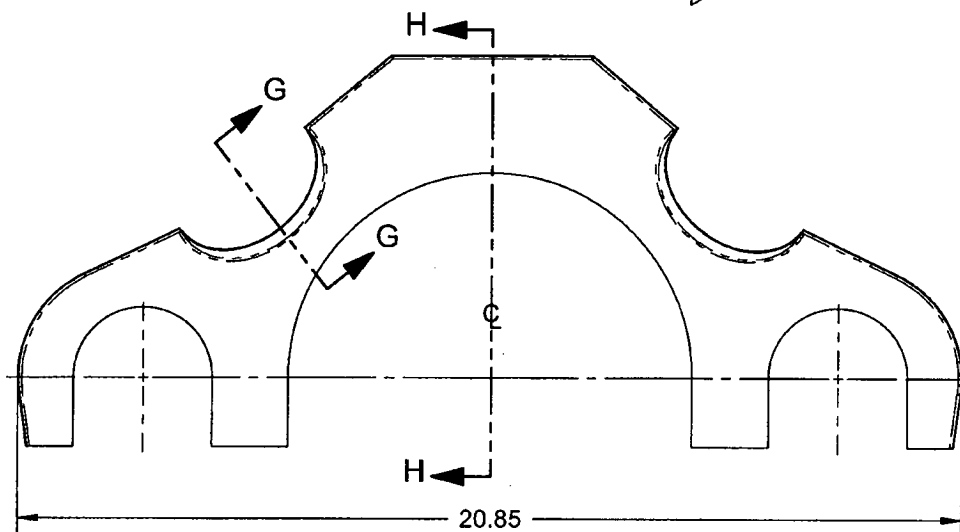
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 9 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
06.05.15**SECTION G-G****SECTION H-H****D3467-5 AFT PLATE BENDING DETAIL****NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

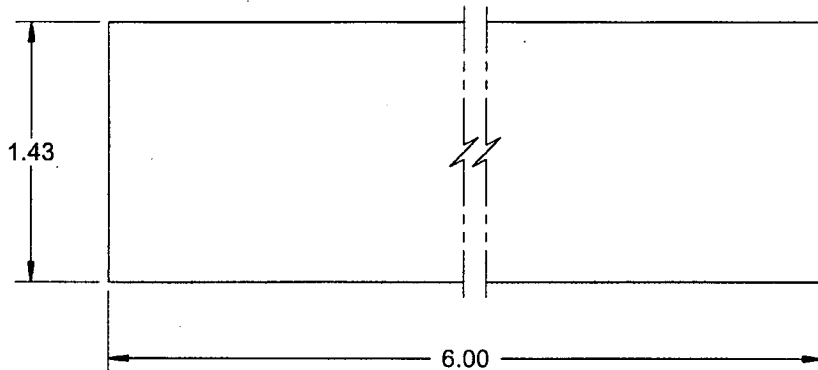
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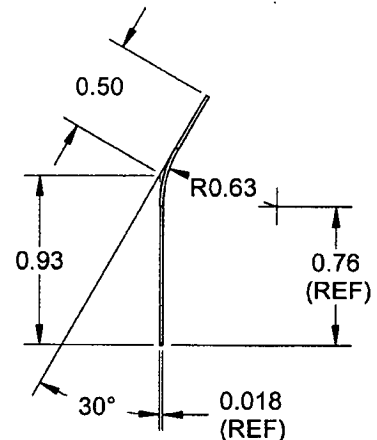
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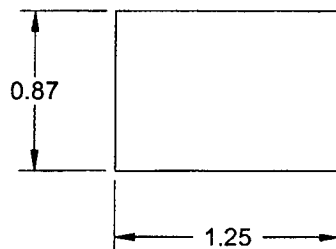
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 10 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

RELEASED
[Stamp]

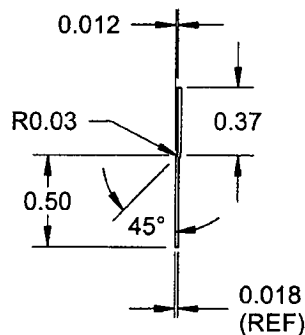
D3467-7F SEAL STRIP
FLAT PATTERN



D3467-7 SEAL STRIP
BENDING DETAIL



D3467-11F BRACKET
FLAT PATTERN



D3467-11 BRACKET
JOGGLE DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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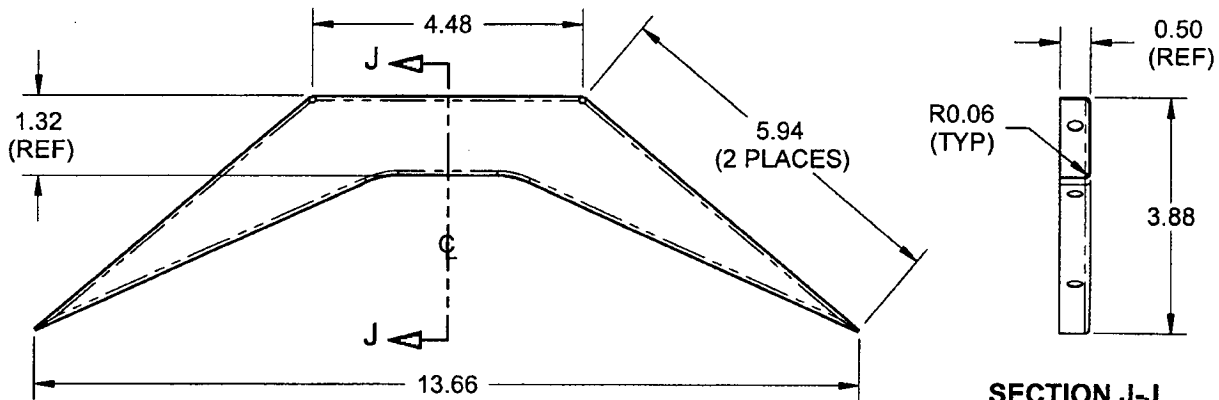
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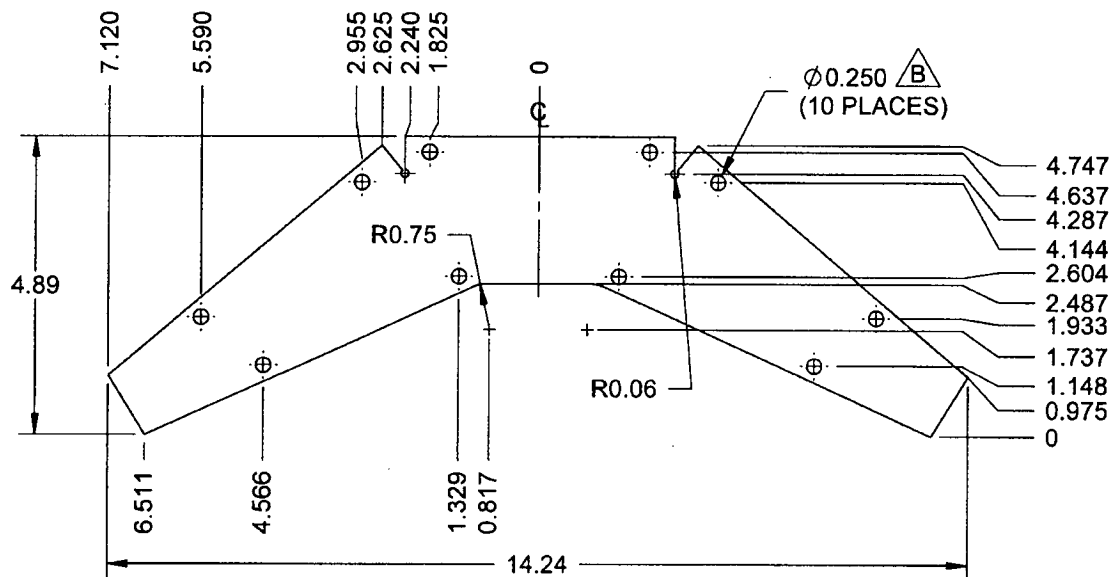


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DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:3

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06.05.15



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH TO AMENDMENT
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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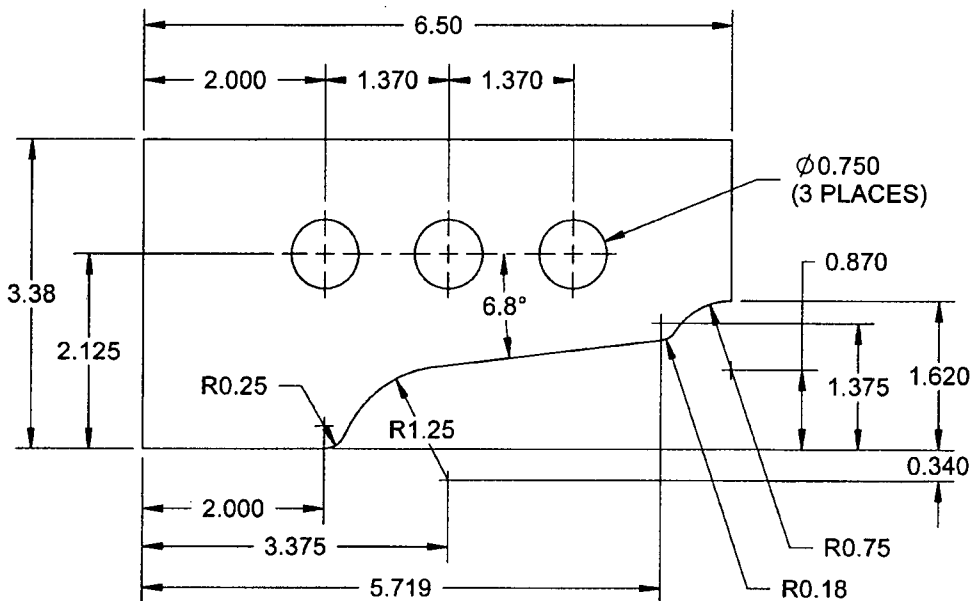
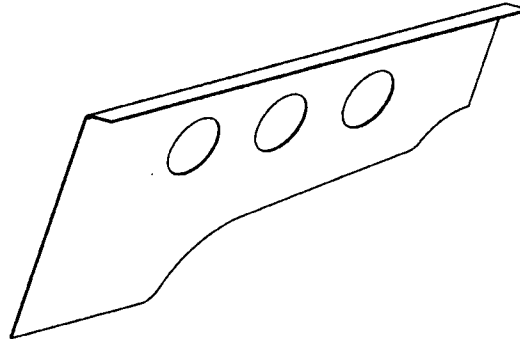
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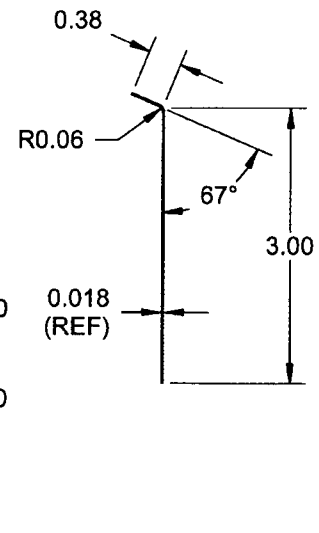


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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06.05.15



**D3467-13F BAFFLE
FLAT PATTERN**



**D3467-13 BAFFLE
BEND DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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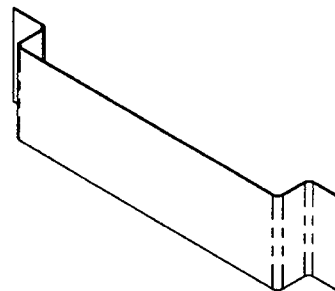
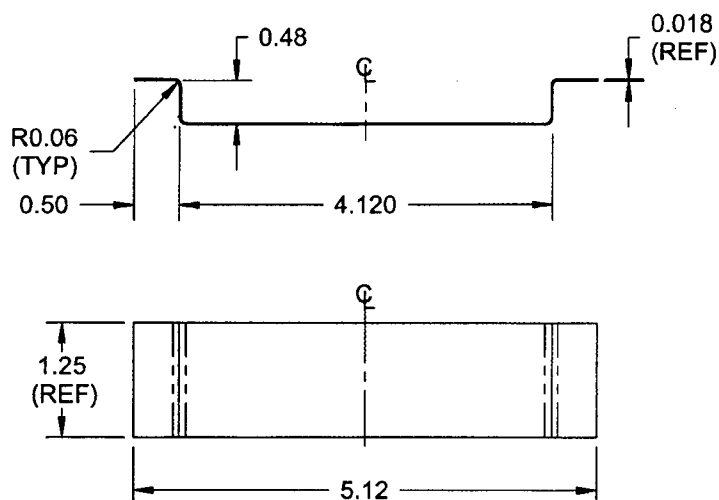
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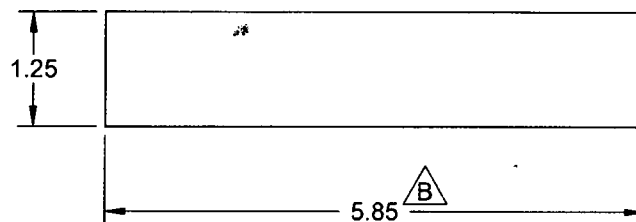


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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[Stamp]



D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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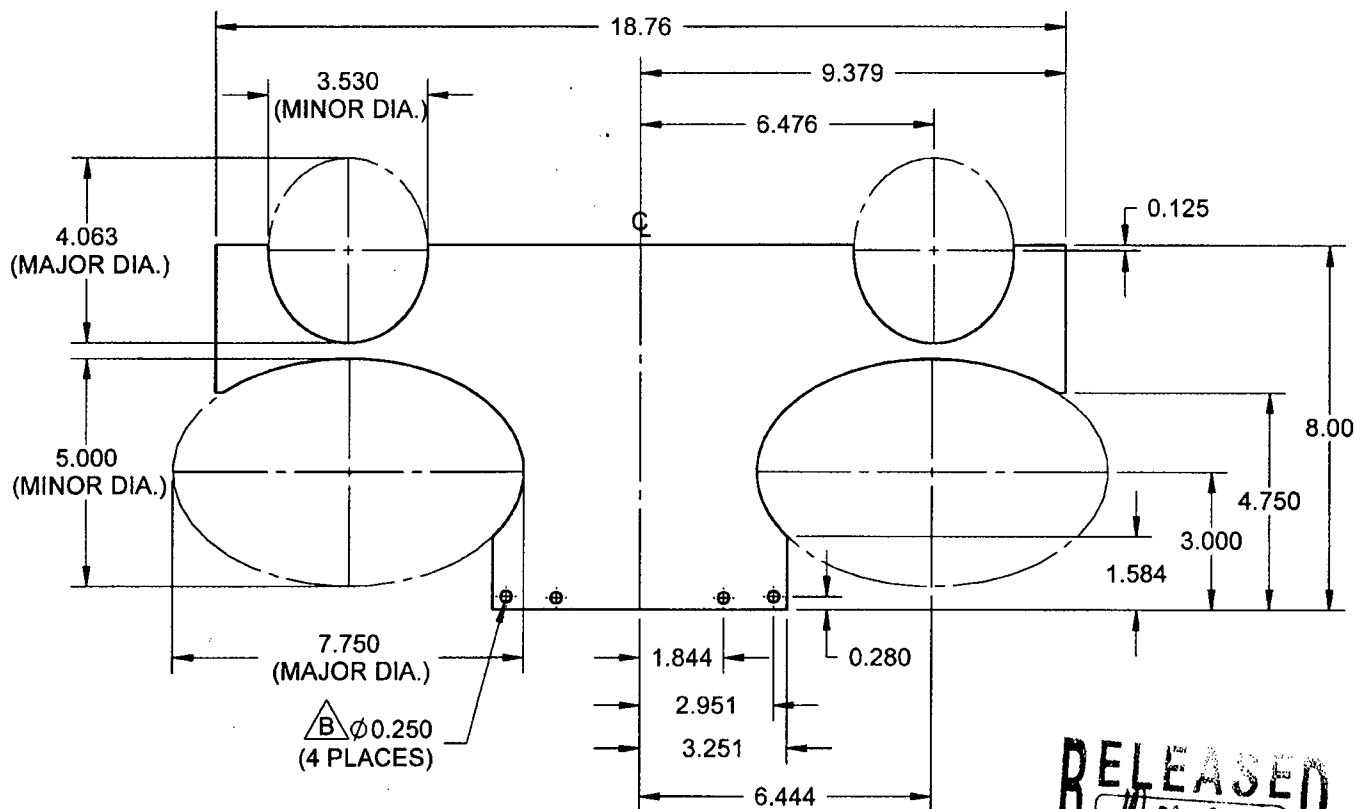
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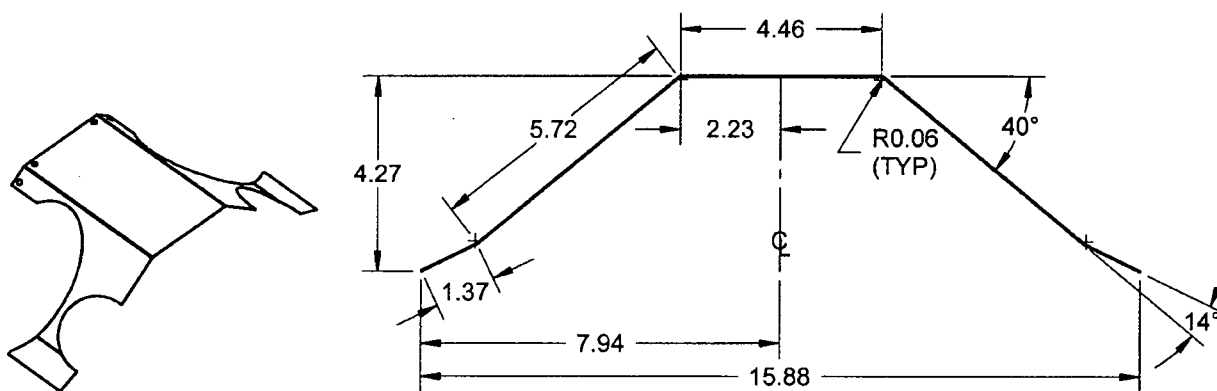


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DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:4



D3467-17F TOP COVER FLAT PATTERN

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#06-05-15



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

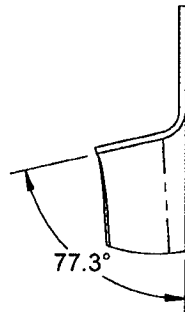
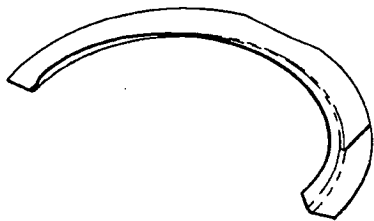
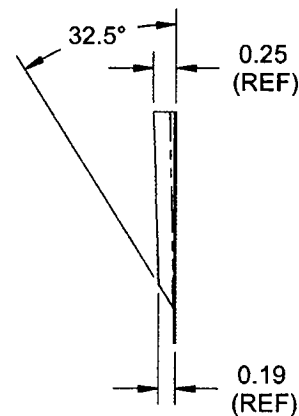
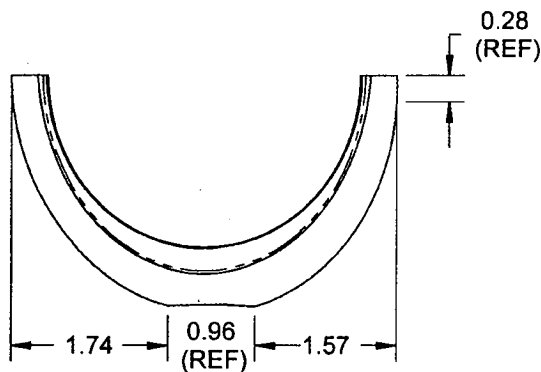
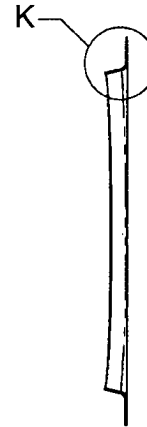
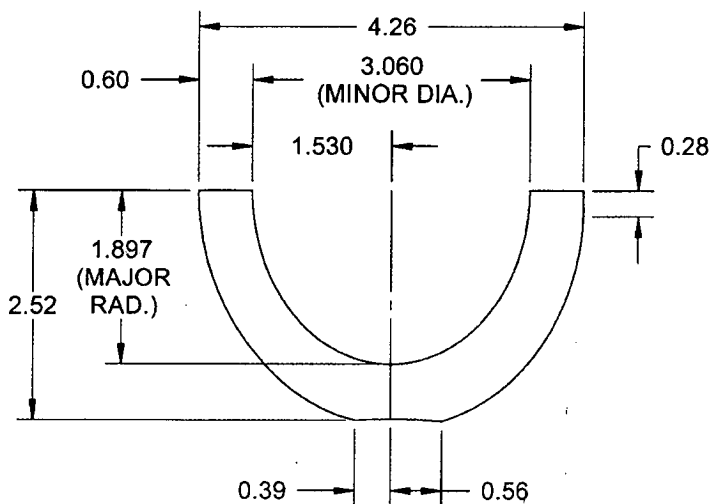
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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[Signature] 06.05.15**DETAIL K**
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**
D3467-20 DOUBLER, R/H OPPOSITESHOP COPY
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NO. **28583****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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